											DQA	:Date:	
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFOR	MANCE / UP	DATE			•
											QA Closed	d: Date	
Work Ord	lor:					DISPOSITION		İ		AGAINST DE	PARTMEN	T/PROCESS	
Work Ord	· -					Rework	7		Skid-tube	Crosstube	7	Water Jet	Engineering
Part	No.					Scrap	1		Machining	Small Fab	Pr	od. Eng. Coor.	Quality
	-	-				Use-as-is	1	1	noforming	Finishing	4	ore/Packaging	Other
NCR	No					Work Order Update			Large Fab	Composite]	Supplier	
Root	Ţ				Descri	ption of work order update	Т	Initial	Ac	tion	Sign &		T
Cause		Date	Step	Qty	l '	or Non-conformance	1	nief Eng		ription	Date	Verification	QC Inspector
Doc/Data	П						T						
Equip/Tooling	П								•				
Operator	П			:									
Material												1	
Setup													
Other													
Process													
Supplier													
Training			•										
Unapproved													
•					 	<u> </u>	AUI	LT CATE	GORY				
Landi	ng G	ear			_	General	_	-			7	_ _	7
	_	Bending				Bend	\vdash	Grain		<u></u>	Ovalized	<u></u>	Pressure/Forced
	Ц	Centre No	t Concer	tric to (o/s	BOM/Route		Hardwa			-3	er tolerance	Temperature/Cure
		Cracks				Broken/Damaged		-i '	on Incomplete		Part Incorr	 	Weld
~	$\boldsymbol{\vdash}$	Çrushed/0	Crimped.			Burrs		4	ions Incomplete/	Unclear	Part Lost/I		Wrong Stock Pulled
	Ц	Cuffs				Contamination		Mainte		<u></u>	Part Move		
	╚	Heat Trea	t			Countersink		Mislabe	led	<u> </u>	Positioned		¬
		nspection	Strip in	Tube		Cut Too Short		Misread			Power Los	s/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

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0.00

Memo

QC

Quality Control

			DQA:	Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		

										QA Closed:	Date:	
Work Ord	er:				DISPOSITION		·		AGAINST DE	PARTMENT,	PROCESS	
Part f					Rework Scrap		Skid-tube Crosstube Machining Small Fal				Water Jet d. Eng. Coor.	Engineering Quality
NCR 1	No				Use-as-is Work Order Update]	Thern	noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	lr	nitial	Ad	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data				•								
Equip/Tooling												
Operator												
Material												
Setup '	•					1	•					,
Other	<u>·</u>											
Process			1 1			1						
Supplier						1						
Training		1				1			;			
Unapproved			<u>. </u>			<u> </u>						
·					F	AUL 1	CATE	GORY				
Landi	ng Gear			-	General	_				1	_	7
	Bending				Bend		Grain	•		Ovalized		Pressure/Forced
	Centre N	ot Concer	ntric to C)/S	BOM/Route	<u> </u>	Hardwa	re	<u> </u>	Over/Under		Temperature/Cure
	Cracks				Broken/Damaged	\square	Inspecti	on Incomplete		Part Incorred		Weld
	Crushed/	Crimped.			Burrs	Ш'	Instruct	ions Incomplete	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
•	Heat Trea	at		L	Countersink	\square	Mislabe	led	<u></u>	Positioned V		1
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes	Ц	Offset					
	Torque V	Vaves in E	xtrusion		Drawing	_		Calibration				
	Turning S	equence			Finish		Out of S	iequenće			· · · · · · · · · · · · · · · · · · ·	
Ī	Wave/Tw	vist in Tub	e	Γ	Folio		Outside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde			*88427*									Page 3
Revision ID:	D412-711-10			Accept	*N900	<u>1040</u>	100)* ፡	•	tart Stop	*N:	S1* S2*
	8/06/12	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item Customer:						ı	
Approvals:	Process Pla	nn:	Date:	Tooling:	D	ate:	-	ì	Run S	tart	*N	R1*
rippi ovais.						ate:			S	top	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp
160				0.00								DAS
160		HAND FINISHING THI	ERMOFORMING					~ ²				07
HandThermo		Memo		0.00				- A-				12 7000
Hand Finishing The	rmoforming	1) Trim off blemishes	excess flange material	2) Buff out any light scra 3) Etch part number and b								(4/08/2)
170		QC2- Inspect parts off m	nachine FAI/FAIB	0.00								DAG
170								v2				07
.QC		Memo		0.00				X- -	-			10/000
Quality Control		1) Visualiy	inspect for clarity, and	proper formation.								13/08/27

180

180

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

1) Visually inspect for clarity, and proper formation.

NCR: Yes / No					WORK ORDER NON-C	CONFOR	MANCE / UP		DQA: QA Closed:	Date: _ Date: _	•
Work Order:		,			DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update	1 1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	l	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	otion of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	c	or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector

Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Ovalized Pressure/Forced Bend Grain Bending BOM/Route Temperature/Cure Over/Under tolerance Centre Not Concentric to O/S Hardware Broken/Damaged Inspection Incomplete Part Incorrect Weld Cracks Wrong Stock Pulled Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Maintenance Part Moved Cuffs Contamination abeled Positioned Wrong Heat Treat Countersink Other Misread Power Loss/Surge Inspection Strip in Tube Cut Too Short **Drill Holes** Ripples in Bend Offset Drawing Out of Calibration Torque Waves in Extrusion **Turning Sequence** Finish Out of Sequence

Outside Dimensions

Wave/Twist in Tube

Folio

Doc/Data
Equip/Tooling
Operator

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Work Order ID 88427 Page 4 August-02-12 9:01:39 AM D412-711-101 *N900040100* Item ID: Accept Setup Start **Revision ID:** Stop Replacement Bubble Window **Item Name:** Start Qty: 2.00 **Start Date:** 8/06/12 **Cust Item ID:** Required Date: 8/17/12 Req'd Qty: 2.00 **Customer:** Reference: Run Tooling: Process Plan: Date: Date: Approvals: Stop SPC (Y/N): Date: OC: Date: Reject Operation Accept Sequence ID/ Set Up/ Tool ID Tool # Plan Reject Insp. Number Stamp Qty Qty **Work Center ID** Code Description Run Hours, QC4-100% Inspect kits for completeness 185 *125* Memo Quality Control Identify as per dwg & Stock Location: 0.00 190 *100* 0.00 Packaging Memo Packaging QC21- Final Inspection - Work Order Release 0.00 200 MCZ 15/08/30 0.00 Memo Quality Control

											DO	QA:	Date	•	
NCR:	Yes	/ No				WORK ORDER NON-	co	NFORM	MANCE / UP	DATE		_			
											QA Clos	ed:	Date		
Work Ord	~~.					DISPOSITION				AGAINST DI	EPARTME	ENT/	PROCESS		
Work Ord	er. –				 	Rework	7		Skid-tube	Crosstube	7		Water Jet	Engineeri	ing
Part I	No.					Scrap	1	E .	Machining	Small Fab	1	Prod	I. Eng. Coor.	Qual	-
	_					Use-as-is	1	Therm	noforming	Finishing	Rec/	Stor	e/Packaging	Oth	ner
NCR I	No					Work Order Update			Large Fab	Composite			Supplier		
Root	1 1 1					tion of work order update	Τ	Initial	Ac	tion	Sign 8	<u> </u>			
Cause		Date	Step	Qty	(or Non-conformance	C	hief Eng	Desc	ription	Date	2	Verification	QC Insp	ector
Doc/Data	Ш														
Equip/Tooling	Ш					,									
Operator	Ш														
Material														,	
Setup	Щ														
Other	Ш											:			
Process	Щ											ļ			
Supplier	Ш		,									ļ		}	
Training	Ц		i'												
Unapproved				<u> </u>			1_				<u> </u>			<u>. </u>	
		(5 -					AU	LT CATE	GORY						
Landi						General	_	٦		<u> </u>	٦		_	7,/r.	
	${f H}$	Bending				Bend	\vdash	Grain		<u> </u>	Ovalized			Pressure/Fo	
		Centre No	t Concer	ntric to C)/5	BOM/Route	\vdash	Hardwa					tolerance	Temperatur	e/Cure
	-	cracks				Broken/Damaged	-	-d '	on Incomplete		Part Inco		}	Weld	المحال ما
	\vdash	rushed/	Crimped.		ļ	Burrs	-		ions Incomplete/	Unclear	Part Los		ssing	Wrong Stoc	k Pulled
	_	uffs			<u> </u>	Contamination	\vdash	Mainte		<u> -</u>	Part Moved				
	\vdash	leat Trea			<u> </u>	Countersink	<u> </u>	Mislabe		·	Position] 	
	_	nspection	•	Tube	<u> </u>	Cut Too Short	\vdash	Misread		L	Power L	oss/S	urge	Other	
	Ripples in Bend				1	Drill Holes		Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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August-02-12 9:01:38 AM

Work Order ID:

88427

Parent Item:

D412-711-101

Parent Item Name:

Replacement Bubble Window

Start Date: 8/06/12

Required Date: 8/17/12

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A New Issue 06-02-01 10/06/28 DL

JLM

IPP Rev. B. Manufacture in-house

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.236		Purchased	No				sf	480.8055		42.666667		-DA	5/ 5%
Plexiglass G .236"				Location therm		<u>Loc Qty</u> 480.8054524	<u>Lo</u>	c Code				, 20 12/	08/27
					9 347 - 9 972 2537 2582	0.803174 0.00227844 288 192			40).67sg 1	ΡŁ	·	·

											DQA:	Dat	te:	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFOR	MANCE / UPDATE					
											QA Closed:	Dat	te:	
Work Ord	or:					DISPOSITION			AGAINS	PARTMENT	/PROCESS		·	
VVOIR OIG	CI.					Rework	1	ļ	Skid-tube Crosstub	e 🗀]	Water Jet		Engineering
Part I	No.					Scrap	1	Machining Small Fa		Pro	d. Eng. Coor.		Quality	
						Use-as-is	Thern	noforming Finishir	ıg 🗀	Rec/Sto	re/Packaging		Other	
NCR	No.					Work Order Update			Large Fab Composi	te]	Supplier		
Root	i I I I				Descri	ption of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty	c	or Non-conformance	Ct	nief Eng	Description		Date	Verification	n	QC Inspector
Doc/Data														
Equip/Tooling		-												
Operator														
Material														
Setup									,					
Other														
Process	Ш		ļ											
Supplier						e de la companya de l			•] .			
Training														
Unapproved			<u> </u>	<u> </u>							<u> </u>			
						F	AUL	LT CATE	GORY					
Landi						General		.		_	1	I		1
		Bending				Bend		Grain		\vdash	Ovalized			Pressure/Forced
	-	Centre No	ot Concer	ntric to O	/s	BOM/Route	_	Hardwa		<u> </u>	Over/Under			Temperature/Cure
		Cracks			ļ	Broken/Damaged	<u></u>	4 '	on Incomplete	<u> </u>	Part Incorre		<u> </u>	Weld
	_	Crushed/	Crimped.		<u> </u>	Burrs		4	ions Incomplete/Unclear	<u> </u>	Part Lost/M	- '	<u> </u>	Wrong Stock Pulled
	\vdash	Cuffs				Contamination	<u></u>	Mainte		L	Part Moved			
	-	Heat Trea			<u></u>	Countersink	<u> </u>	Mislabeled			Positioned V		_	1
		Inspection		Tube		Cut Too Short	_	Misread	1	L	Power Loss/	Surge	<u> </u>	Other
		Ripples in	Bend			Drill Holes	1	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

DART AEROSPACE LTD	Work Order:	88427
Description: Replacement Window	Part Number:	D412-711-101
Inspection Dwg: D412-711-101 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

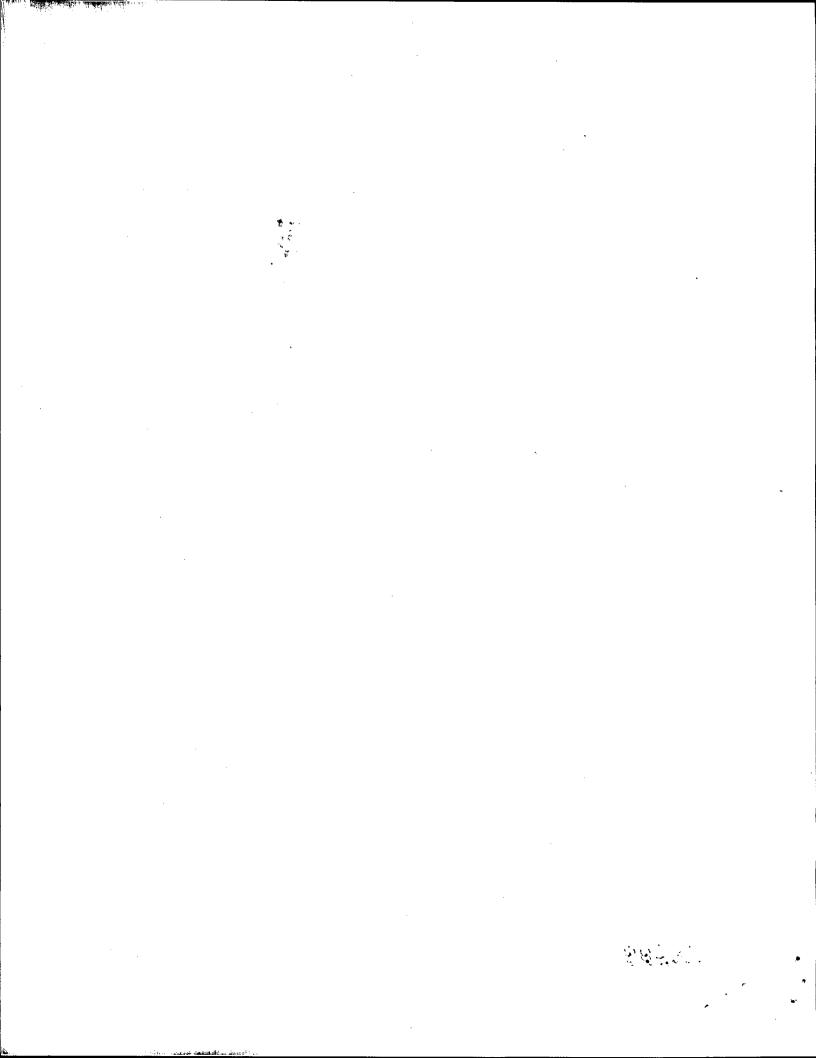
THERMOFORMING SECTION

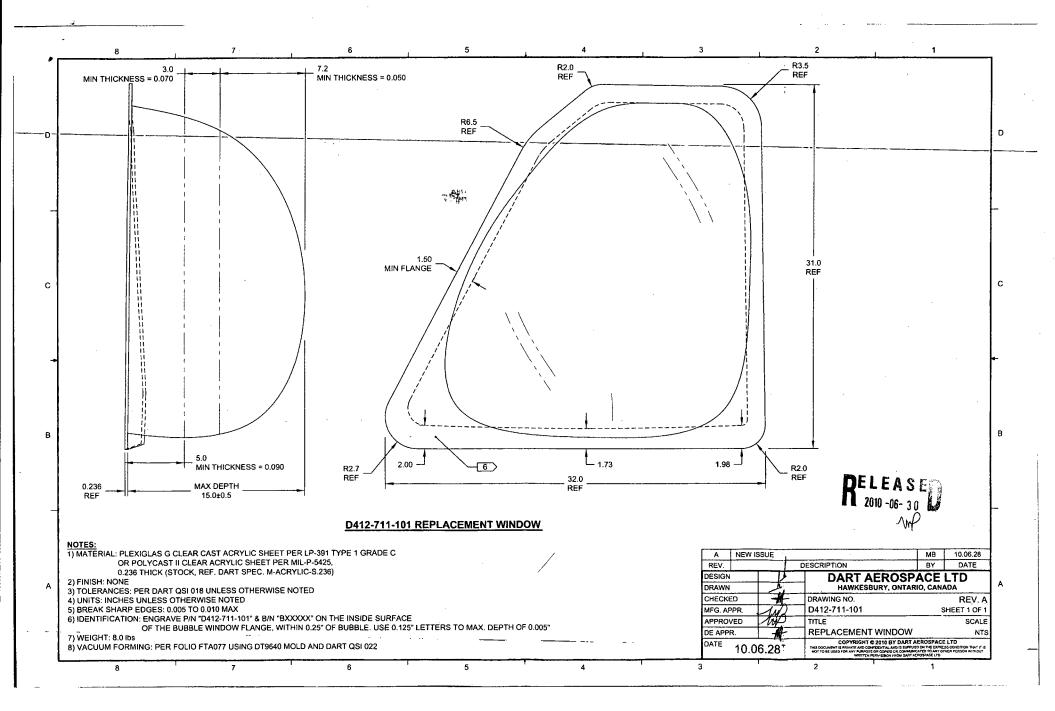
Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than"				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				
· · · · · · · · · · · · · · · · · · ·				
Measured by:			Date:	12/08/23

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	+/-0.030	2.05"	_		Ven DL-02	
-1.73	-+/-0.030					Remove FRO
1.98	+/-0.030	1,98511	V		VenDL-03	-
1.50	Min	1.55"	~		Vern DZ-02	
0.090	Min	0.108*)		ULTRA	
0.070	Min	0.098"	\		ULTRA	
0.050	Min	0,075"	\		ULTRA	
15.0	+/-0.5	15,0"			TAPEDL-0	7
	/69-0 [1				
Measured by	1 (20)/(g)/			Date:	12/08/27
Audited by		7/05/78			Date:	
Preliminary Approval		, , , ,			Date:	

Rev	Date	Change	Revis			Appro	yed
В	10.10.08	New Issue	KJ	X	7-		
				7	7		





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